



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872882-7
Job Sheet 183466



Part No: RB6872882-7

Job Qty: 2 ea

Part Name: Body Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/11/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB6872882 Rev. 5 IPP Rev. A 18.09.17 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		10/11/18	0.00	0.00	Start Up Large Fab-7		
100	Large Fab	2 pcs		10/11/18	0.00	4.00	Large Fab 8		
110	QC	2 pcs		10/11/18	0.00	0.00	QC9		
115	QC	2 pcs		10/11/18	0.00	0.00	QC5		
120	Lathe Conv	2 pcs		10/11/18	0.00	4.00	Lathe Conv-2		
130	QC	2 pcs		10/11/18	0.00	0.00	QC2 Machining-5		
140	QC	2 pcs		10/11/18	0.00	0.00	QC8 Machining-5		
150	Outsource	2 pcs		10/11/18	0.00	0.00	Outsource12		
160	Packaging	2 pcs		10/11/18	0.00	0.00	Packaging2		
170	QC	2 pcs		10/11/18	0.00	0.00	QC6		
180	Packaging	2 pcs		10/11/18	0.00	0.00	Packaging3-2		
190	QC21-SA	2 Ea		10/11/18	0.00	0.00	QC21		

Part Op 100 - Weld as per DWG.

Descriptions: 120 - 1-Machine as per DWG. 2-Debur

150 - Issue P/O to GROUPE ALTECH; PO 0411618 - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6872882-7A	Body Bottom	2 Ea (1 ea)	90-Start up Operation	5118382
RB6872882-7B	Body Column	6 Ea (3 ea)	90-Start up Operation	5117186
RB6872882-7C	Body Top	2 Ea (1 ea)	90-Start up Operation	5118621



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S120189



Part: RB6872882-7

Job No: 183466

Serial No/Batch: S120189

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 10/22/18

Required	Inventory	Allocated
8	0	0
18	0	0
2	0	0

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240
25
26

10/11/1987

10/11/1987

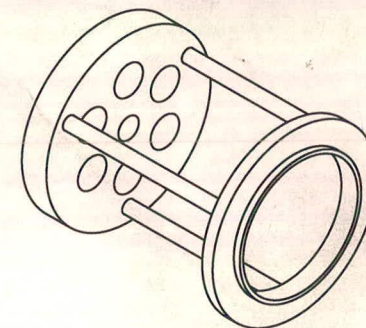
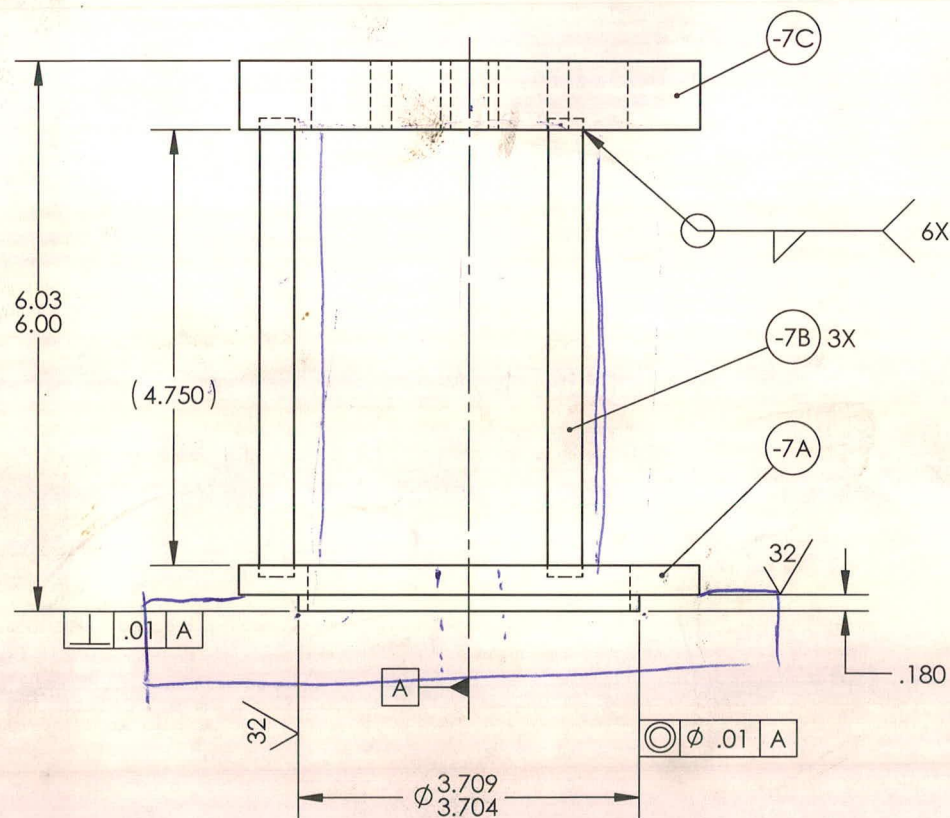
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10/11/1987
10/11/1987

Part Specifications
Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		ADDED -7 ASSEMBLY HEIGHT & TOL, CHANGED -1: 3/16 S.F. PIN TO P.F.	1/02/07	WP
5	17-0110	-7 CH'D WELD CALLOUT WAS FAR SIDE IS NEAR SIDE. CH'D DATUM A TO CENTERLINE, DELETED CONCENTRIC CONTROL ON O.D. ADDED DIMS Ø3.709/3.704 CONCENTRIC Ø.01 TO DATUM A. .180. ADDED SURFACE FINISH 32 ON MACHINED SURFACES. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC



DART AEROSPACE	
TITLE PULLER, TURBINE FRONT BEARING	
DWG NO. RB6872882-7	REV 5
MAT'L REAR TREAT FINISH SPEC DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL ALLISON 250 SERIES
SCALE 1:2	DATE 5/18/2007
SHEET 7 OF 13	

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :							



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PURCHASE ORDER **PO041618**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041618
PO Date: 11/6/18
Due Date: 11/14/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185209	RBE117-12020W19	Mounting Tool Seal Main Transmission -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	11/14/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71

5 X NOV 14 2018

Line Item Note: ** Need by Nov. 14, Please confirm**



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PURCHASE ORDER **PO041618**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	183466	RB6872882-7	Body Weldment -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/14/18	2 pcs	0 pcs	2 pcs	\$17.142857/pcs	\$34.29
Grand Total:										\$120.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/7/18 11:45 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014188-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

014188- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Nov-2018		Jessie Boisvert		041618				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir/ Back Order
1	RBE117-12020W19 ✓ Rev.	RBE117-12020W19 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	5	5	0	0	0
2	RB6872882-7 ✓ Rev.	RB6872882-7 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	2	2	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

